Abstract

The recoiling temperature of a metal strip from a continuous heat treatment line is controlled by continuously passing the metal strip through an accumulator system where it passes around spaced accumulator rolls. While travelling through the accumulator, the metal strip is subjected to ambient cooling air and the length of aluminum strip travelling through the accumulator determines the amount of cooling that takes place. The length of the metal strip in the accumulator is in turn controlled by varying spacing between the accumulator rolls around which the metal strip travels. The spacing is preferably controlled by a programmed controller in response to temperature signals.